

Date: Thursday, 4/20/2006 7:13:13 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY LOW SKID LH
 Job Number : 26681
 Estimate Number : 12365
 P.O. Number : N/A Part Number : D350591215
 This Issue : 4/20/2006 S.O. No. : N/A Drawing Number : D3168 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : 4/18/2006 Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 5/4/2006 Qty: 4 Um: Each
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est Rev: A 02.10.17 New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile and type labels as per PPP D350-591-215 CHG001

KS 06/04/27 (4)

2.0 D2622120C Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)
 EXTRUSION
 Batch B24563=3 B24092=1

KE 06.04.20 4

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

KE 06.04.20 (PTD) 4

2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)

KE 06.04.20 4

3-Deburr

KE 06.04.20 4

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-04-20 (4)

5.0 D30671 End Plate


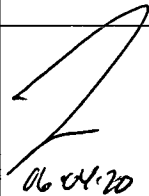
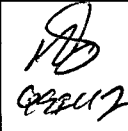
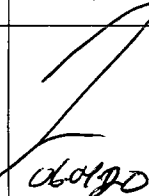


Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 END PLATE
 Batch B26411

KE 06.04.20 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-20	3.0	4 aft rivet holes were drilled wt. 6 holes each side instead of 8. Human error on 1st step.		Fill holes with weld and ground flush as per QS1004 Retrain Welder "Hussy Bear"	LE 06-04-20	 06-04-20		 06-04-20

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 7:13:13 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID LH

Job Number: 26681

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31691

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SUPPORT

Batch: 3.25200

RE. 06.04.20 4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

RE. 06.04.20 4

2-Weld Support using Jig DT8781, weld Fwd End Plate as per QSI 004 & Dwg D3168

RE. 06.04.21 4

A/R Aluminum Rod M18838 M19173

3-Grind End Plate flush

Weld F. 06.04.24

8.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work

RE. 06.04.22
PD 06.04.27 4

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RE. 06.04.29 4

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06.05.04 4

11.0

D30771

Step Leg



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

STEP LEG

Batch: 26684

FF 06.05.04 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 7:13:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID LH

Job Number: 26681

Part Number: D350591215

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D31701	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPACER

Batch

26686

FF

06.05.04

4

13.0	MS20600AD4W4	Rivets
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

RIVET

Batch

M18499

= 49

FF

06.05.04

4

14.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3168

FF

06.05.04

4

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-05

4

16.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

END PLATE

Batch

326411

FE

06.05.05

4

17.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod m18838

4-Grind End Plate flush

FF 06.05.05 4

FE 06.05.06 4

FE 06.05.06 4

FE 06.05.06 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 7:13:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID LH

Job Number: 26681

Part Number: D350591215

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	QC5/9	WELD INSPECTION
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Comment: Inspect work & Weld - Check dimension 51.90" as per Dwg D3168

Handwritten signature

PD 06-05-09

19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Touch Up Chemical conversion

DL 06/05/09

(4)

20.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten signature
DL 06/05/10

(4)

21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D3168 and QSI 005 4.4

FC 06-05-11

(4)

22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: Inspect Powder Coat and Wing Walk

23.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

24.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.3000 f(s)/Unit Total : 1.2000 f(s)
RUBBER CUSHION

2 D2182B035 Rubber Cushion Batch B24870

25.0	D2274	Radius Block
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
RADIUS BLOCK
Batch B26078

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID LH

Job Number: 26681

Part Number: D350591215

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D2732	Rubber Extrusion
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Comment: Qty.: 0.5000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

Batch

N/A

W

27.0	D2856400	Abrasion Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

ABRASION STRIP

1 D2856-400 (7.2") Abrasion Strip Batch

B26041

X

28.0	D30641	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

CLAMP

Batch

B23406

✓

29.0	D30801	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

CLAMP

Batch

B21677

✓

30.0	AN335A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch

M19551

✓

31.0	AN411A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch

M17771

✓

32.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

Batch

M100743

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 7:13:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY LOW SKID LH

Job Number: 26681

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

WASHER

Batch M100575 ✓

34.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Batch M18917 ✓

35.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

NUT

Batch M19085 ✓

06/05/16 (4)

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/16 (4)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-215

Location: _____

PPP Rev: B

06/05/17 (4)

38.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/18 (4)

Job Completion



06-05-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *f*

REFERENCE ONLY

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

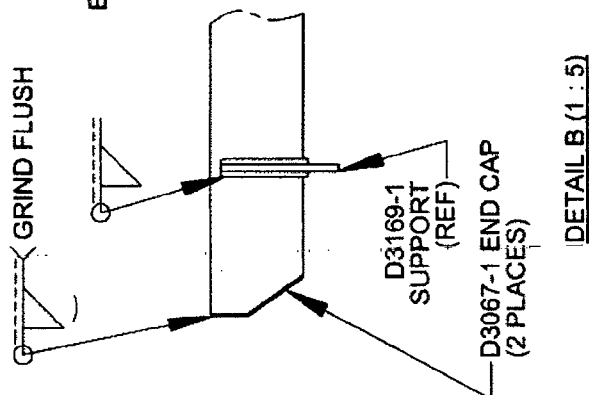
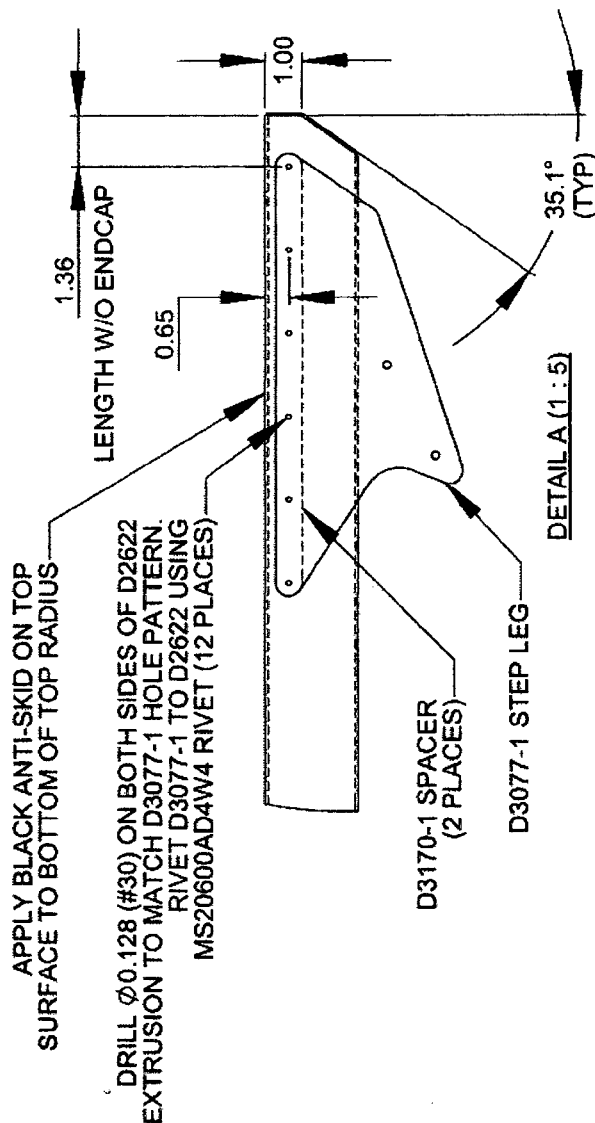
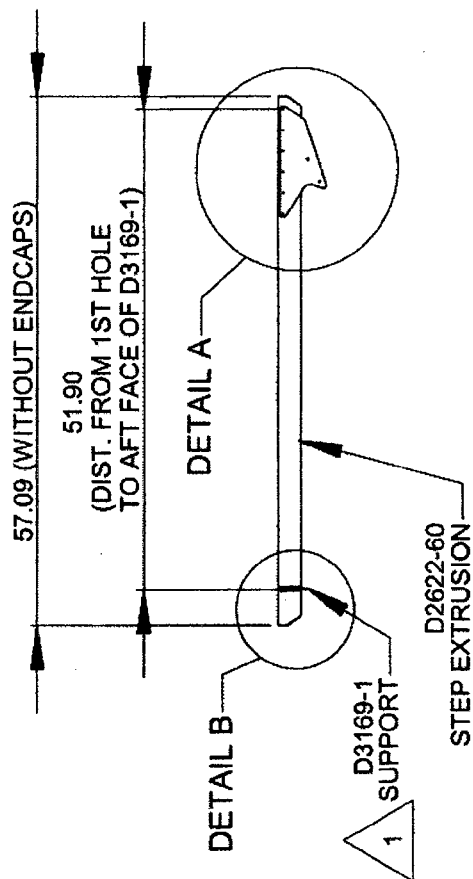
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DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3168	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT	SCALE 1:20

RELEASED
02.09.20



REFERENCE ONLY

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Date: Friday, 6/23/2006 3:02:21 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D350-591-211/-212/-213/-214/-215/-216
 Job Number : 27682
 Estimate Number : 10804
 P.O. Number : N/A Part Number : Z_CUSTOM
 This Issue : 6/23/2006 S.O. No. : N/A Drawing Number : ADD PARTS & PAPERWORK
 Prsht Rev. : NC Project Number : N/A
 First Issue : 6/23/2006 Type : N/A Drawing Revision : N/A
 Previous Run : 00015 Material : N/A
 Written By : SEE ABOVE WORK & INVT Due Date : 6/30/2006 Qty: 24 Um: Each
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSI9340011 STEP MOD KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 24.0000 Each(s)
 STEP MOD KIT

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD TO KITS IN STOCK

1 X DSI 9340-011 B 27681

STOCK AFFECTED:

D350-591-211 (4 X B18906) ok

D350-591-212 (0)

D350-591-213 (6 X B27432) ok

D350-591-214 (7 X B26656 / 2 X B25434) ok

D350-591-215 (2 X B26681) ok

D350-591-216 (2 X B25753 / 1 X B26732) ok

Remove: D2182 B035
 D3080-1
 D3064-1

Old new labels
 27681
 27682
 27683
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 27685
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 27688
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 27699
 27700

3.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP & RETURN TO STK

134 67
 235 46
 62 32
 8 X B18750
 4 X B23406
 4 X B 26667
 D3064-1

132.68

27681
 27682
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